

Work Order ID 128245

128245

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Tuesday, January 13, 2015 1:34:54 PM

Item ID: D4095-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Center
Start Date: 1/13/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-01-14 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-5)								
364.063	Dwg Rev: <u>B</u>								
	Prog Rev: <u>R</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(6)

12/15/01/30

(6)

12/15/01/30

(6)

DAS
38
9-89

JAN 30 2015

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 Required Date: 1/20/2015 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00			DAS 30 9-89	6		FEB 18 2015	
Brake NC	Memo	0.00			DAS 28 9-89	6X		FEB 18 2015	
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				(6)			DAS 38 9-89
Quality Control	Memo	0.00							
150 *150* HandFinish		0.00				6			DAS 41 9-89
Hand Finishing	Memo	0.00							
	COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <u>131233</u>								15-2-18

FEB 18 2015

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Start Date: 1/13/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS
160									38
QC	Memo	0.00							9-89
Quality Control									

FEB 20 2015

170	Identify as per dwg & Stock Location: <u>FR-002</u>	0.00
170		
Packaging	Memo	0.00
Packaging		

x6 of 21 15/02/23

180	QC21- Final Inspection - Work Order Release	0.00
180		
QC	Memo	0.00
Quality Control		

15/2/23

APR 5-2-23

Picklist Print

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Work Order ID: 128245

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Parent Item: D4095-045

D4095-045

Parent Item Name: Wearplate Center

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.10.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	52.9057	1.03	5			

M304S16GA

304/316 Sheet .063

01/15/2015

Location

Loc Qty

Loc Code

MAT019

52.9057

M129192

23.2995

M129449

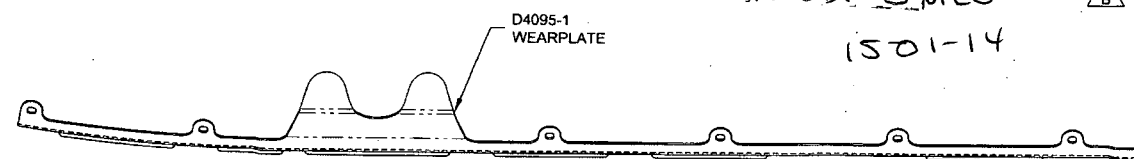
29.6062

131384

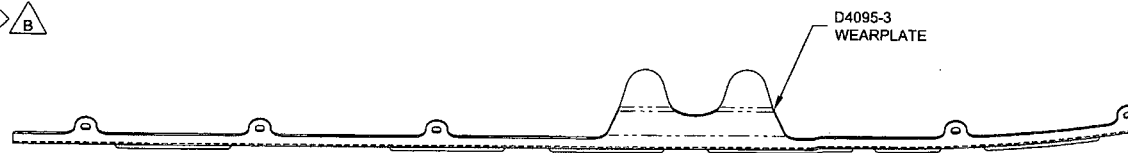
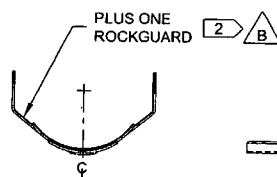
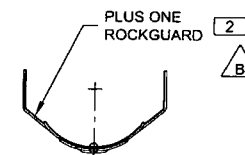
8.5

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

UNCONTROLLED COPY
 WORK IN PROGRESS
 128245 M.L.S
 1501-14



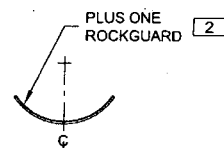
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



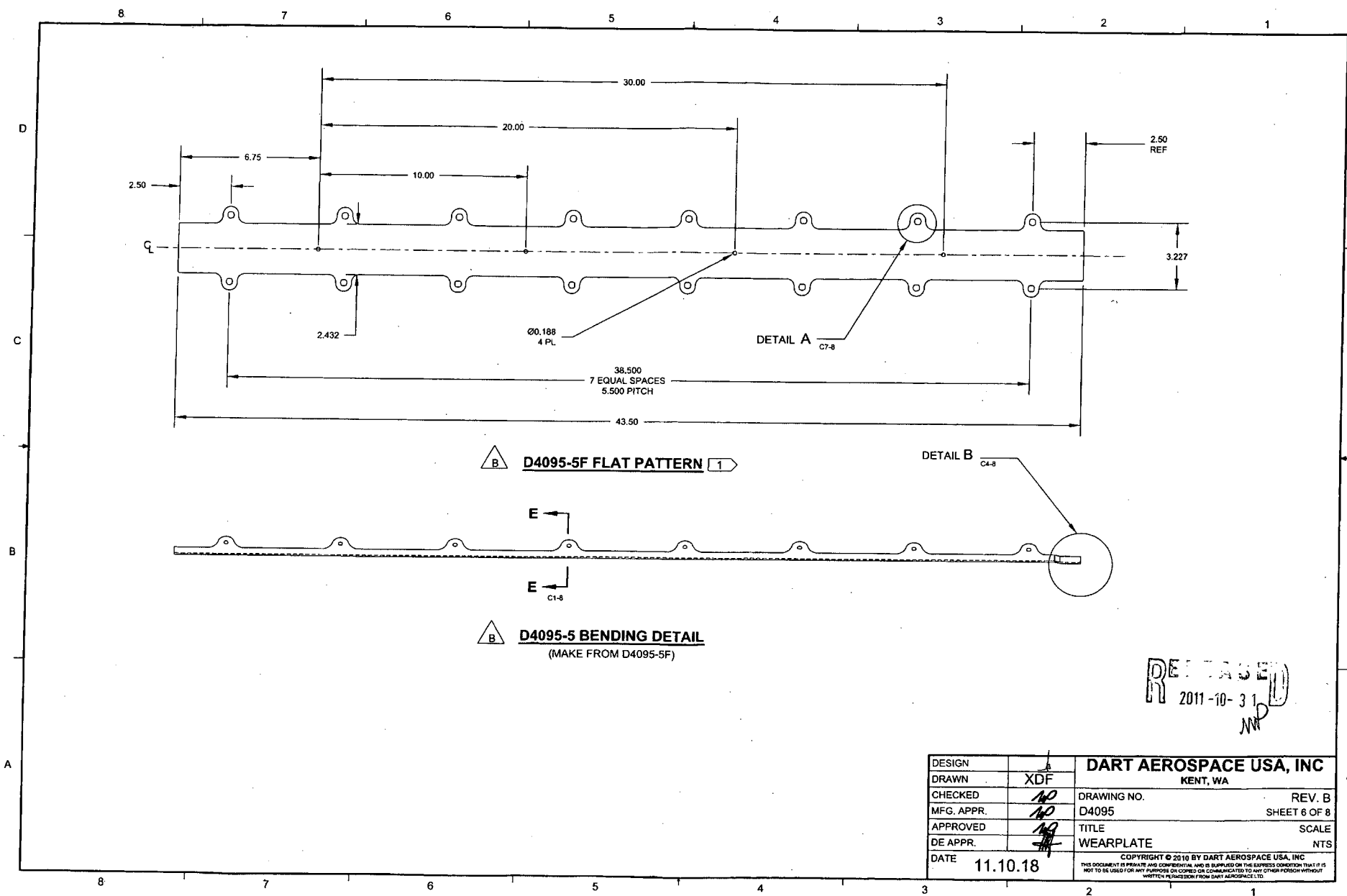
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	11.10.18		

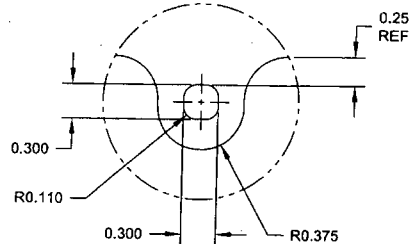
DART AEROSPACE USA, INC
 KENT, WA
 DRAWING NO. D4095
 TITLE WEARPLATE
 REV. B SHEET 1 OF 8
 SCALE NTS

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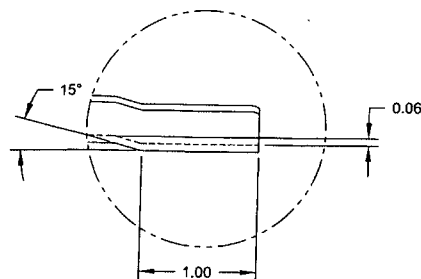
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DRAWN	XDF	KENT, WA	
CHECKED	110	DRAWING NO.	REV. B
MFG. APPR.	110	D4095	SHEET 6 OF 8
APPROVED	110	TITLE	SCALE
DE APPR.	110	WEARPLATE	NTS
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DETAIL A: TAB DETAIL

SCALE 4X

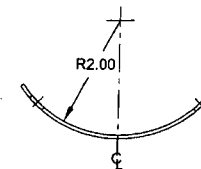
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

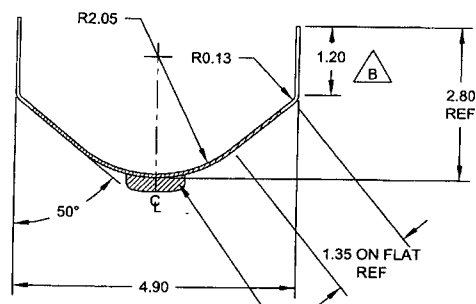
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B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

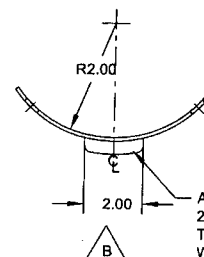


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

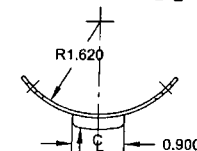


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

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2011-10-31

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MFG. APPR.	<i>[Signature]</i>	D4095	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
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